

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006166**Date Inspected:** 07-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Huajie & Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as CB203C (Side A). The weld designations reviewed are as follows:

Bay 1

1. CB203C-001-001 2. CB203C-001-002
3. CB203C-001-003 4. CB203C-001-004

Bay 10

This QA inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as Tower Bearings Shear Plate. The weld designations reviewed are as follows:

1. ED1-A27A/E-51A and 51B

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Bay 7

This QA Inspector observed the following work in progress:

SMAW tack welding of weld joint 015~024 located on PCMK SP554-001

Welder is identified as Mr. Chen Dingding (048923). ZPMC QC is identified as Wu Zhi Feng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM.

SMAW tack welding of weld joint 014~020 located on PCMK SP634-001

Welder is identified as Mr. Wang Hongbo (203206). ZPMC QC is identified as Wu Zhi Feng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM.

Bay 6

This QA Inspector observed the following work in progress:

FCAW tack welding of weld joint 26, 27 and 28 located on PCMK WD1-CBSA-1-8

Welder is identified as Mr. Zhang Liang (209554). ZPMC QC is identified as Liu Huajie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-B-P4-F-1.

SMAW tack welding of weld joint 30, 33, 35, 47 and 49 located on PCMK WD1-CBSA-1-2

Welder is identified as Mr. Zhang Liang (049769). ZPMC QC is identified as Liu Huajie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2314-Tc-P4-FCM.

Bay 1

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 026 located on PCMK DP522-001

Welder is identified as Mr. Yang Fuzhi (219188). ZPMC QC is identified as Chen Xi.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint 88~91 located on PCMK DP522-001

Welder is identified as Mr. Yang Fuzhi (219188). ZPMC QC is identified as Chen Xi.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

Bay 13

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 223 located on PCMK SSD46-PP11

Welder is identified as Mr. Wang Li (044772). ZPMC QC is identified as Shi Lei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM.

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Bay 11

This QA Inspector observed the following work in progress:

SAW welding of weld joint 21B located on PCMK WSD1-FBSA3-2A/C

Welder is identified as Mr. Li Jitang (044552). ZPMC QC is identified as Li Ming

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

Bay 10

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 5A located on PCMK SSD1-TL5B/L

Welder is identified as Mr. Chen Xiaoya (209076). ZPMC QC is identified as Li Ming

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
